

July 15

July 15

Work Order ID 71040

Tuesday, June 21, 2011 1:13:52 PM



Page 1

Item ID: D3407-043

Accept



Setup Start



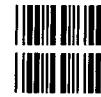
Revision ID:

Item Name: Tow Ring

Stop



Start Date: 6/21/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 11/06/21

Tooling:

Date: _____

Run

Start



QC:

Date: _____

SPC (Y/N):

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3407

Rev E

100



Large Fab

Large Fab

Memo

0.00

0.00

EL 11/06/27

(X6)

Large Fab

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI
004 A/R TIG174 ROD Batch: M101972

110



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

0.00

PL 11/06/27

Quality Control

120



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

0.00

5/11/06/27

(X6)

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 2

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125



SprayPaint

Memo

PRIME B 117319
DELFLEET BLUE B 115985
DELFLEET CLEAR B 117113

0.00

W 11-06-28(6)

135



QC

Quality Control

QC14- Inspect Spray Paint

0.00

T 11-06-29(6)

150



Packaging

Packaging

Identify as per dwg & Stock Location: ST 420

0.00

L JB (6) 11/06/29

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

16/06/2011

11/06/29
④

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 1:13:59 PM

Page 1

Work Order ID: 71040



Parent Item: D3407-043



Parent Item Name: Tow Ring

Start Date: 6/21/2011

Required Date: 7/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 05.10.14 New issue KJ/EC

IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-3 		Manufactured	No			100	Each	0.0000	1	6		<i>EL 116-27</i>	
Stem				66394 x6									
D3407-5 		Manufactured	No			100	Each	25.0000	1	6		<i>EL 116-27.</i>	
Ring													

Location	Loc Qty	Loc Code
WA030 	25 <i>69742</i>	

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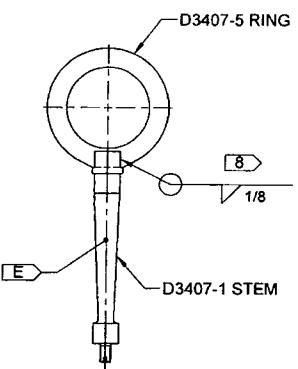
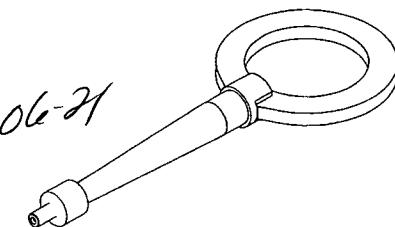
NOTE: Date & initial all entries

E

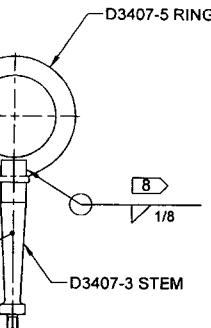
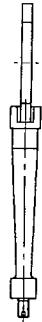
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
1	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *71040*

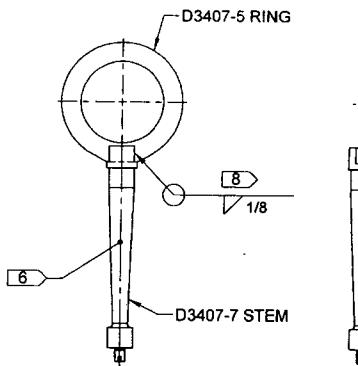
01/11-06-21



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

RELEASED
01/06-21-19

A

NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISION NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>19</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>18</i>	PORT HADLOCK, WA	
CHECKED	<i>18</i>	DRAWING NO. D3407	
MFG. APPR.	<i>18</i>	REV. E	
APPROVED	<i>18</i>	SHEET 1 OF 5	
DE APPR.	<i>18</i>	TITLE TOW RING	
DATE	08.07.23	SCALE NTS	

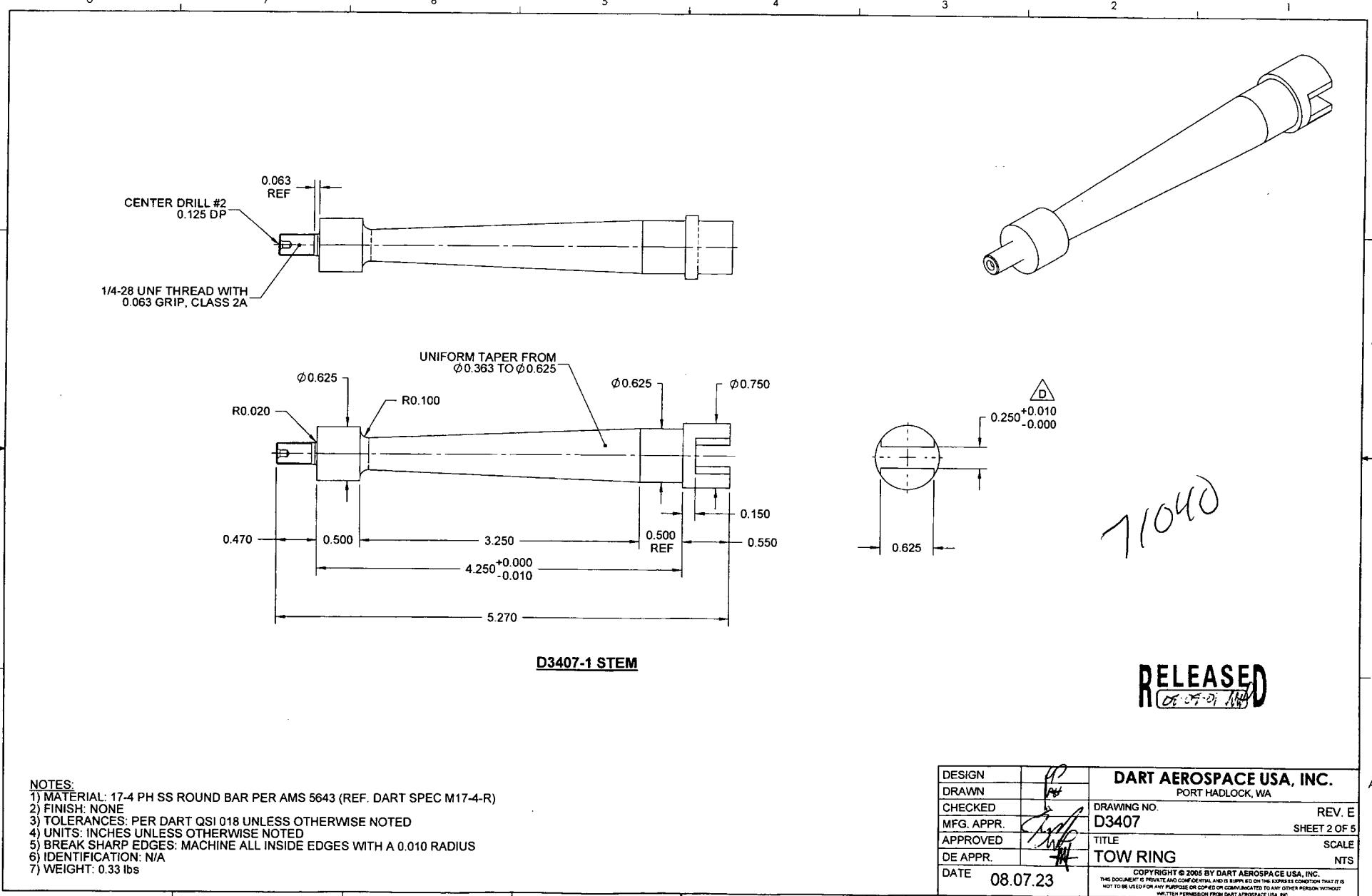
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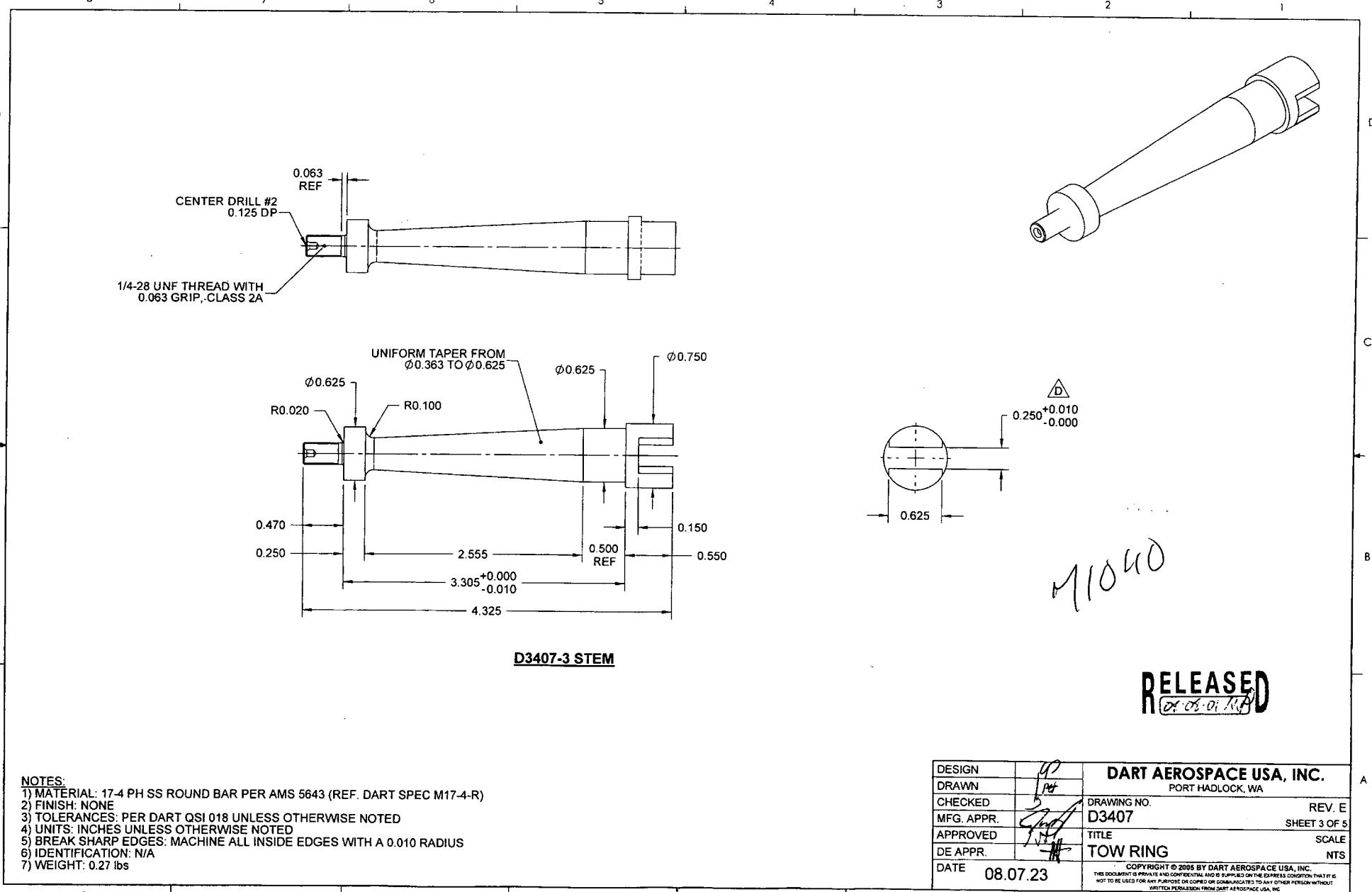


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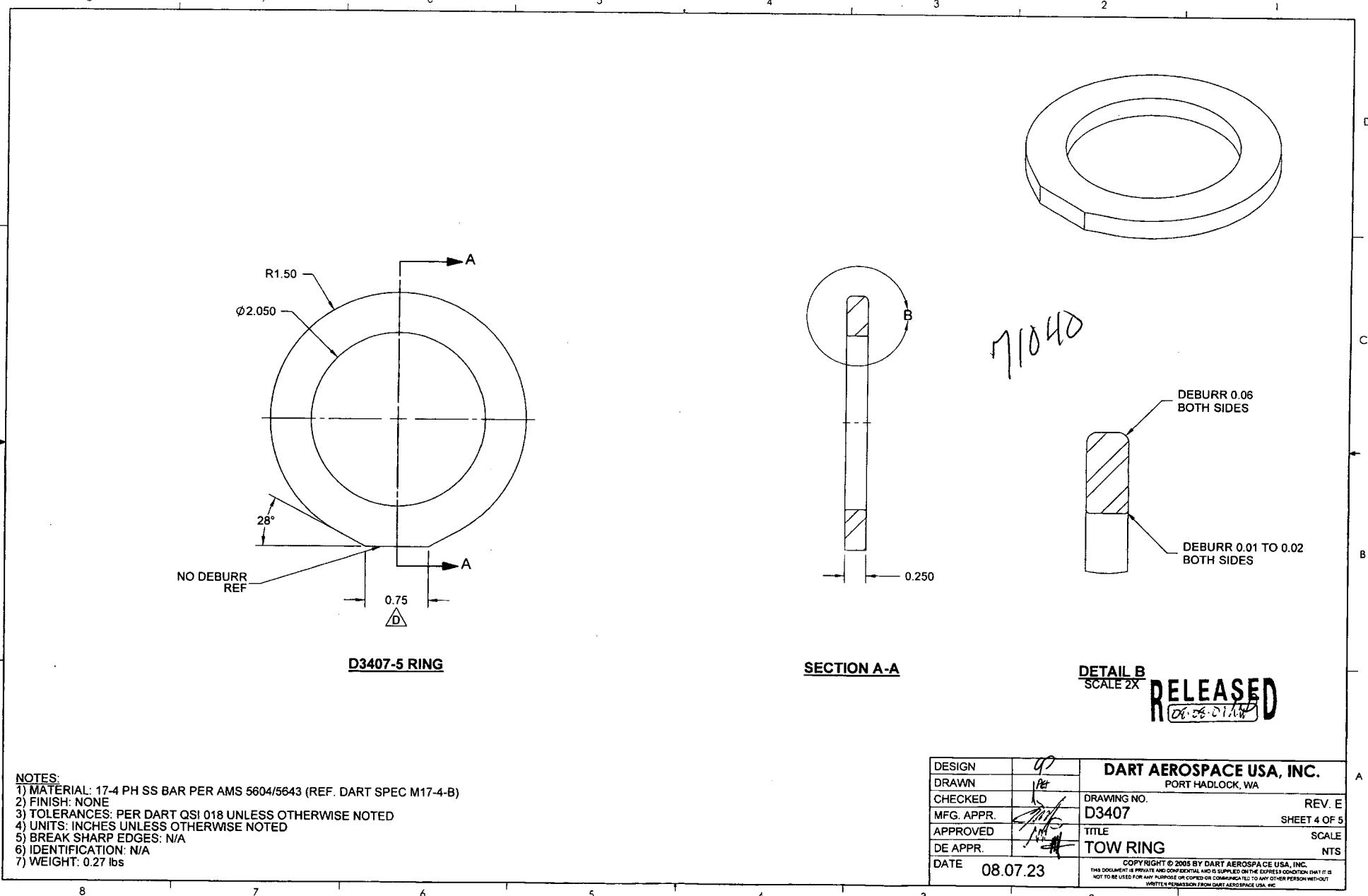


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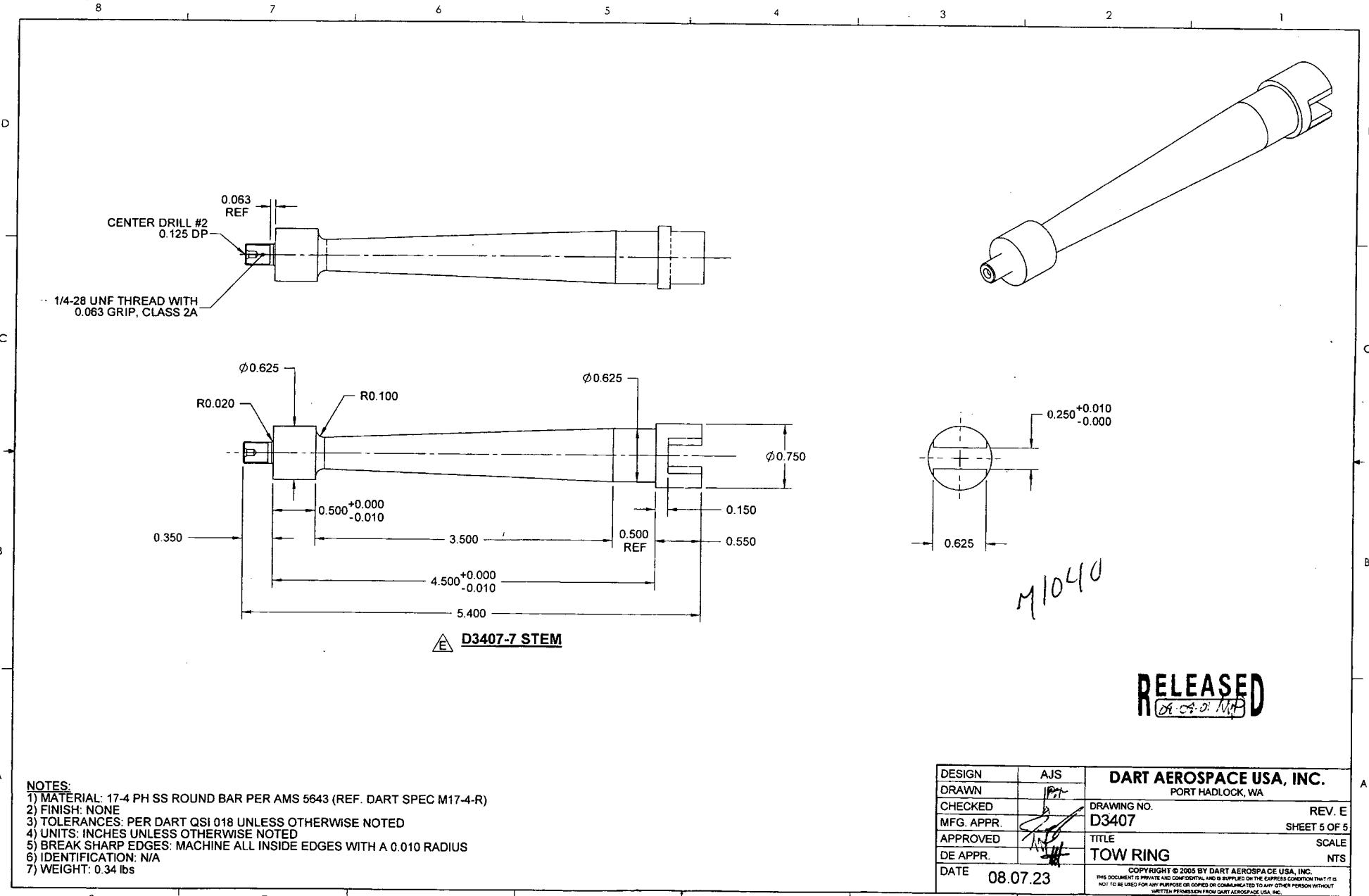


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NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.		
DRAWN	<i>100</i>	PORT HADLOCK, WA		
CHECKED	<i>S</i>	DRAWING NO.	REV. E	
MFG. APPR.	<i>S</i>	D3407	SHEET 5 OF 5	
APPROVED	<i>S</i>	TITLE	SCALE	
DE APPR.	<i>S</i>	TOW RING	NTS	
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